

Date: Wednesday, 10/25/2006 11:14:56 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STA 155 BRACKET - UNDER REVIEW		
Job Number	: 29169					
Estimate Number	: 11040					
P.O. Number	: N/A			Part Number	: D28042	
This Issue	: 10/25/2006	S.O. No.	: N/A	Drawing Number	: D2804 REV B Rev. C Preliminary Issue	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A	Type	: SMALL /MED FAB	Drawing Revision	: UNDER REVIEW 6K Up 06.16.25	
Previous Run	: 28310			Material	:	
Written By	<u>HD</u> Job 10 25			Due Date	: 11/1/2006	
Checked & Approved By				Qty:	78	
Comment	: Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on w/ jetEC			Um:	Each	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"	
		Comment: Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50"	
		Batch: <u>m102508 ml 06 10 27</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: <u>C</u> <u>ml 06 10 27</u> <u>7</u> Prog Rev: <u>B</u>	
		2-Deburr if necessary	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103	<u>ml 06/10/29</u> <u>7</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>ml 06/10/29</u> <u>7</u>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>JL 06/10/30</u> <u>7</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/14/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/25/2006 11:14:57 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET - UNDER REVIEW

Job Number: 29169

Part Number: D28042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

*ML 06/10/29*

7

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*JL 06/10/30*

④

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*YL 06/10/30 x7*

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*SB 06/10/30*

⑦

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*JP 06/10/30*

⑦

Job Completion



*U 06/10/30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29169
Description: STA 155 Bracket	Part Number:	D2804-2
Inspection Dwg: D2804	Rev: <u>f</u> C Preliminary Issue	(D06.16.25)

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

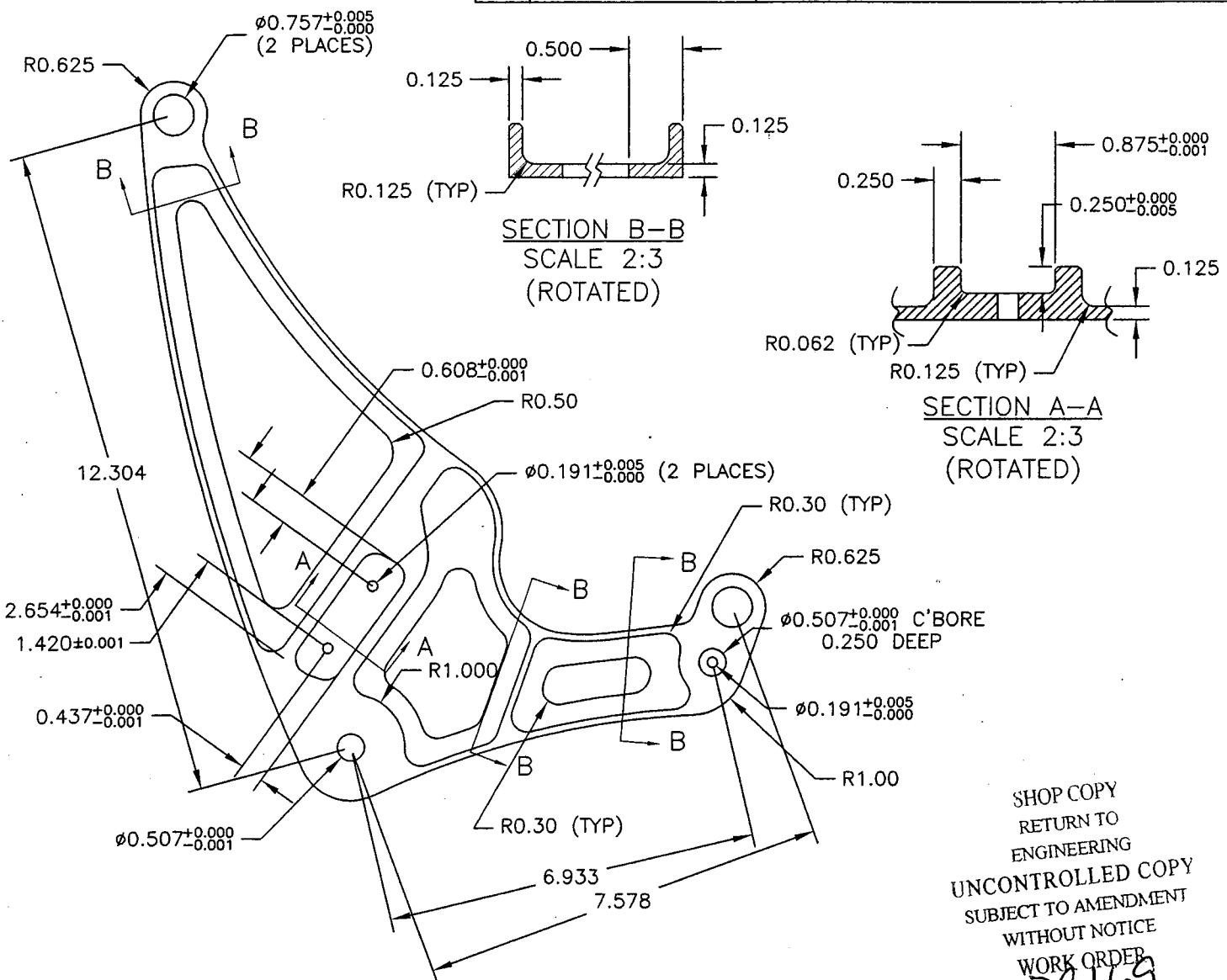
Measured by:	<u>J.W.L</u>	Audited by:	<u>J.L.</u>	Prototype Approval:	N/A
Date:	06/10/29	Date:	06/10/29	Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	<i>[Signature]</i>



**PRELIMINARY ISSUE**

DESIGN	CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED	DRAWING NO. D2804
DATE			REV. C SHEET 1 OF 2
06.10.16			TITLE STA 155 BRACKET
			SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	



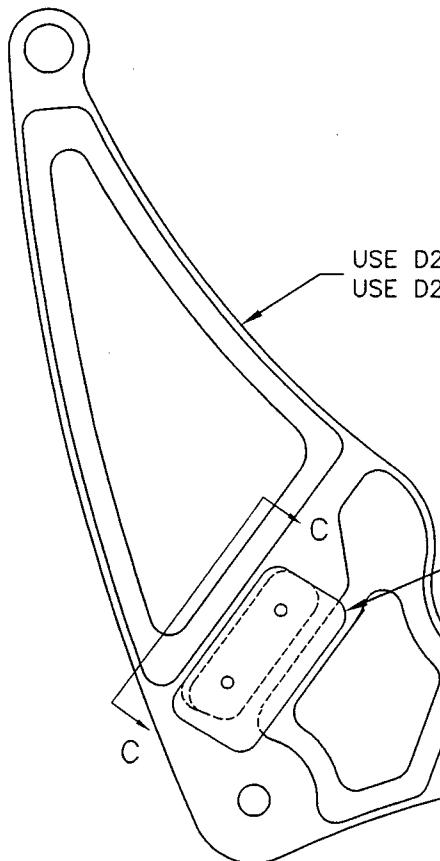
### D2804-1 BRACKET (SHOWN), D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDprt"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

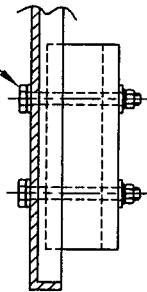


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2804
DATE	TITLE	REV. C SHEET 2 OF 2 SCALE 1:3

# PRELIMINARY ISSUE



AN3C16A BOLT (1)  
NAS1515H3 WASHER (2)  
MS21042-3 NUT (1)  
INSTALL BOLT WITH LPS-3 CORROSION  
INHIBITOR (ENSURE NO LPS-3 ON THREADS)  
(2 PLACES)



USE D2804-1 FOR D2804-041/-043  
USE D2804-2 FOR D2804-042/-044

SECTION C-C  
SCALE 1:3  
(ROTATED)

USE D2805-1 FOR D2804-041  
USE D2805-2 FOR D2804-042  
USE D2805-3 FOR D2804-043  
USE D2805-4 FOR D2804-044  
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO  
POWDER COAT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29169

## D2804-041/-043 BRACKET ASS'Y (SHOWN) D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

- 6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)  
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3